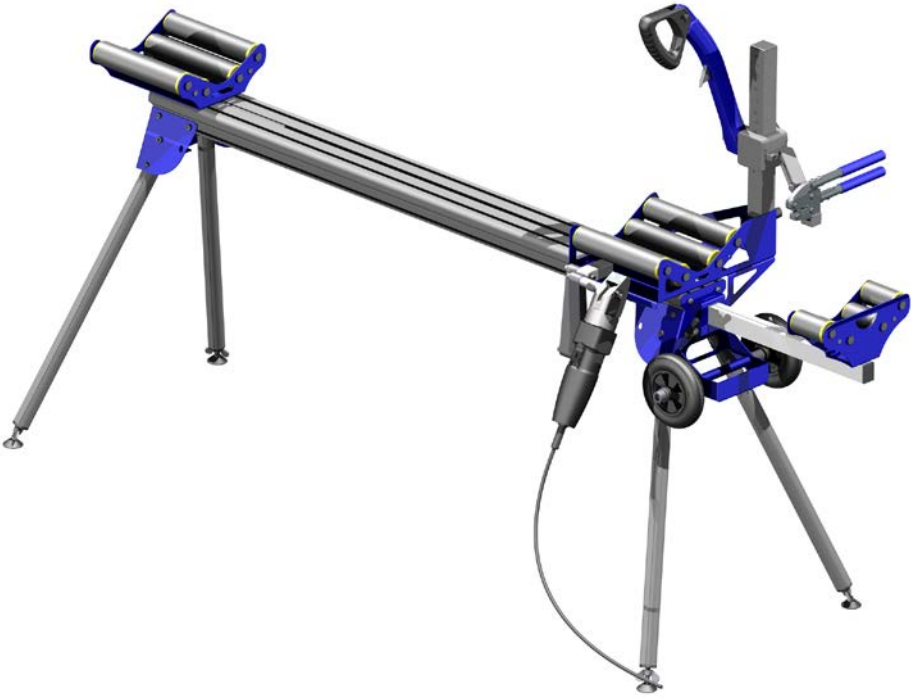


SR Cutter
User Manual

Contents

CE marking	2
Technical data	3
Presentation	4
Preparations for cutting	5
Instructions for cutting	8
Instructions for making notches	11
Instructions for moving the bench	12
Problem solving	13
Spare parts	15
Contact	18

SR Cutter 103427

Declaration of conformity

Lindab hereby declares under sole responsibility that this product complies with the following directives: 2006/42/EG, EMC 2006/95/EG.

CE
103427

Kenneth Lennartsson
CEO, Lindab Ventilation AB

Safety instructions

Read through the manual before you start using the SR Cutter. Keep the manual to hand so that everyone who uses the SR Cutter has access to the manual.

1 **Wear protective goggles**
Risk of chips from the nibbling machine. Risk when cutting the duct's needle.

2 **Use protective gloves**
Risk of cut injury when handling the duct.

3 **Wear ear defenders**
The noise level can vary when cutting the ducts, sometimes it exceeds 85 dB(A). Always wear ear defenders to protect yourself.

4 **Make sure the stand is steady**
Never use the stand on uneven or unsteady surfaces. Make sure the legs are extended correctly and secured tightly before use.

5 **Do not overload the stand**
Do not exceed the maximum workload. Do not climb, sit or stand on the stand.

6 **Do not use in a humid environment**
Risk of electrical short circuit, use together with earth fault breaker.

7 **Protect the electric cable**
Risk of damage to the cable from sharp plate edges.

8 **Assembly and disassembly**
Use the handle to make assembly easier.

9 **Moving**
The SR Cutter must be moved on its own wheels. Avoid heavy loads.

Technical data

Bench – collapsed

Length	1645	mm
Width	470	mm
Height	350	mm

Bench – erected

Length	1880	mm
Length (with extended telescope arm)	3140	mm
Width	630	mm
Height	1180	mm
Maximum permitted load	75,0	kg
Weight	23,0	kg

Part name	Part nr
SRCS2 3000	103 427
SRCS2 3000 US	103 428

Accessories

Shears

Model	3514-7R	
Power	500	W
Voltage	230	V
Stroke frequency	2400	/min
Weight	2,2	kg

CSS EU 230	226 607
CSS UK 110	226 609
CSS CH 230	226 608
CSS US 110	100 886

Needle plier

Lenght	200	mm
Weight	0,35	kg

NCP	226 618

Click plier, small (Ø 80-224)

Length	290	mm
Weight	1,0	kg

Click plier, large (Ø 250-315)

Length	290	mm
Weight	1,1	kg

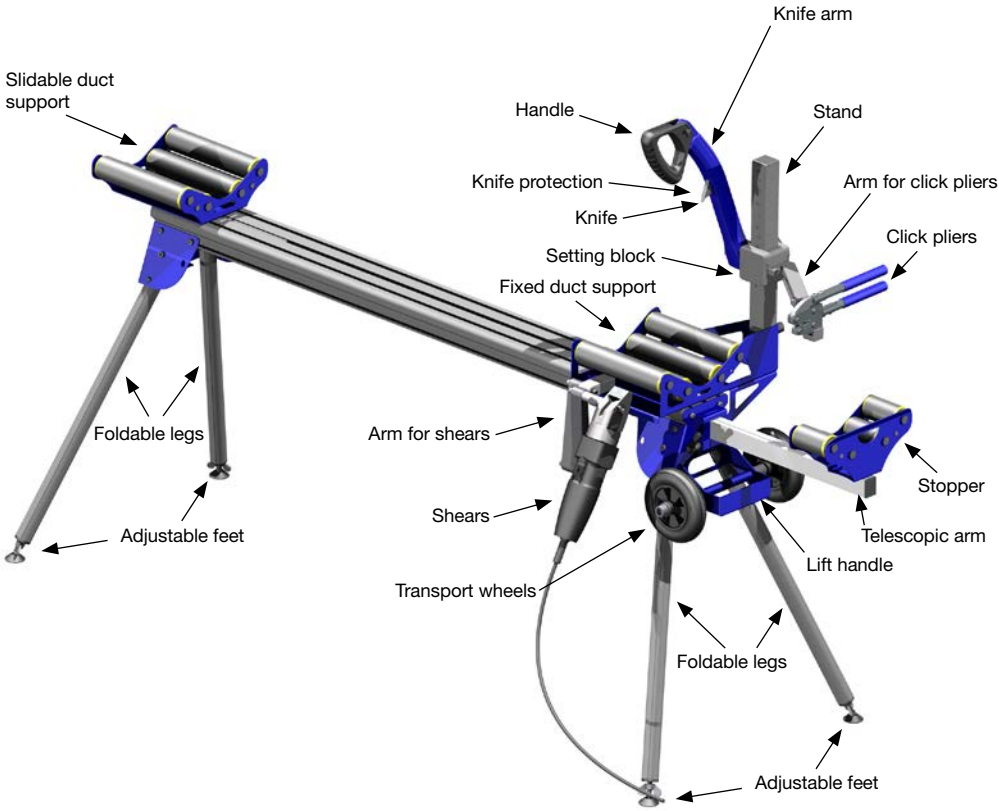
CSCP 40	100 754
CSCP 60	100 755

Arm for click plier

Lenght	210	mm
Weight	0,6	kg

CSCPS 2	103 430

Presentation



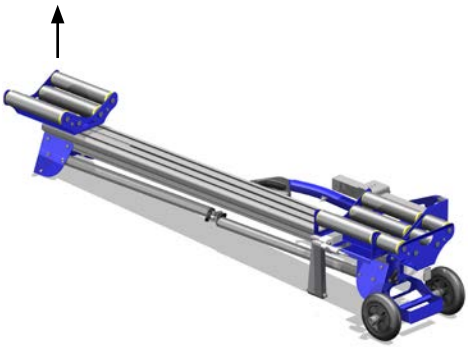
With this workbench you can cut ducts of 80-315 mm diameters and lengths of 200 mm and upwards.

The bench is equipped with:
- Wheels and foldable legs so you can easily move it to wherever you are currently installing ducts.
- Scale for setting the desired duct length.
- Knife to make a hole for the shears.

Accessories:
- Shears to cut the duct.
- Pliers to cut the inner and outer needle.
- Arm for attaching click pliers.
- Pliers to make the notches.

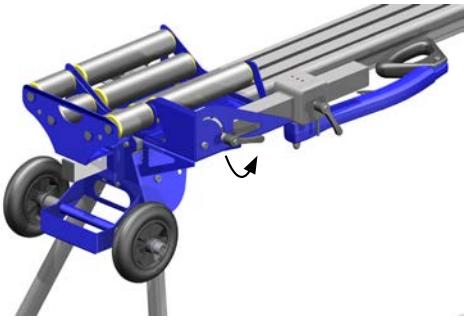
Preparations for cutting

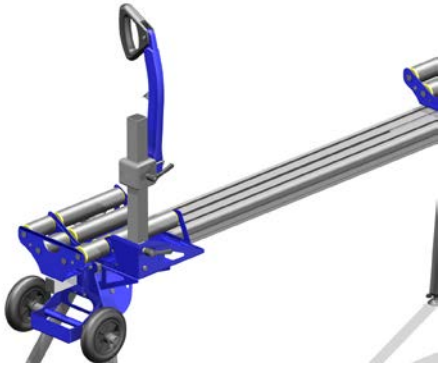
Fold out the bench



1. Lift the bench opposite the wheel side.
2. Press in the buttons and turn out the legs until the buttons have snapped into the correct position for unfolded legs.
3. Lift the bench by the handle on the wheel side.
4. Press in the buttons and turn out the legs until the buttons have snapped into the correct position for unfolded legs.

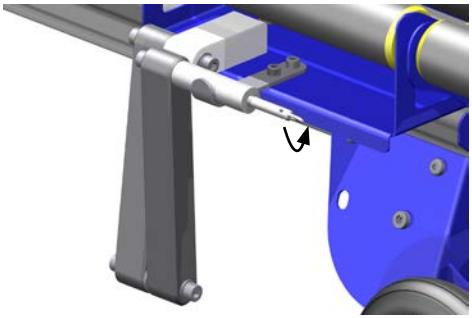
Erect the stand

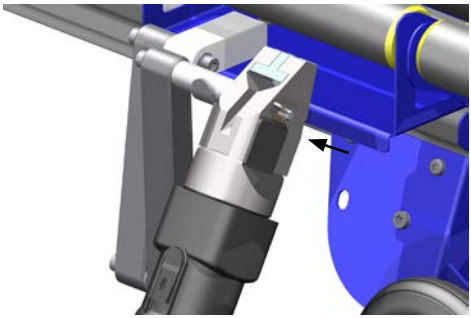




1. Loosen the locking handle on the stand.
2. Move the stand to its vertical position.
3. Tighten the locking handle.

Mount the shears

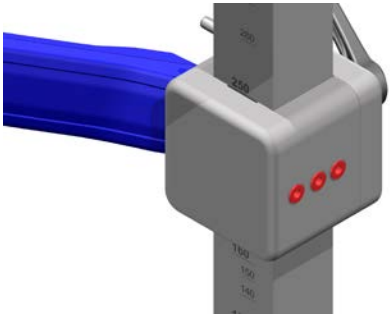


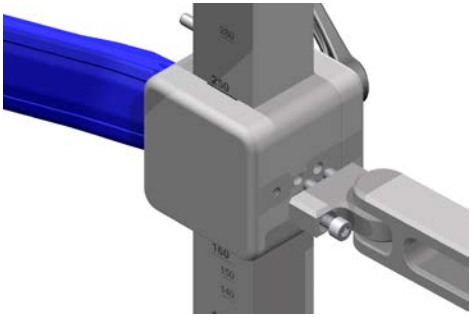


1. Turn the split pin so that it is possible to mount the shears onto the arm.

2. Mount the shears and fold back the split pin so that the pin locks.

Mount the arm for click pliers



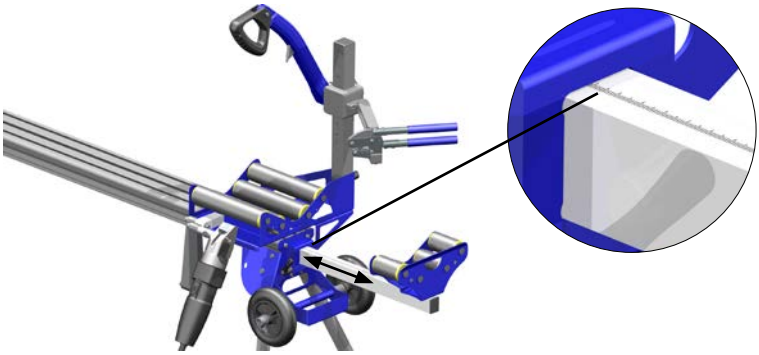


1. Remove the plastic caps from the setting block.

2. Mount the arm so that the pins fits into the holes on the setting block.
3. Tighten the screw.

Instructions for cutting

Set the desired duct length

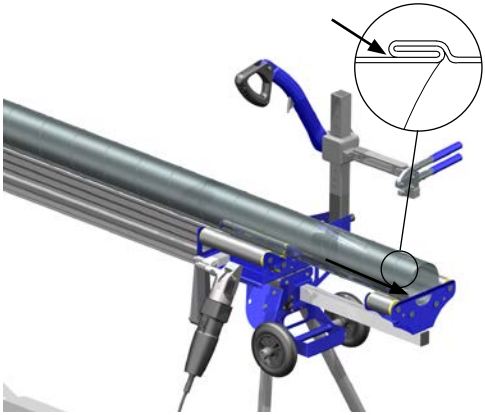


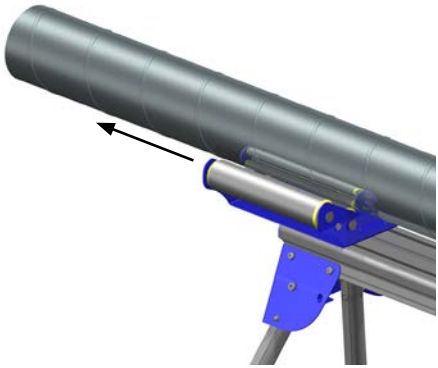
Set the desired duct length, 200–1500 mm:
1. Loosen the telescopic arm's locking handle.
2. Set the desired duct length on the scale on the telescopic arm.
3. Tighten the locking handle.

Set the desired duct length, 1500 mm and longer:
1. Measure how long the duct is that you want to cut.
2. Subtract the length you want your duct to be and the width of the knife (7 mm).
3. Set the result on the scale.

Ex. You measure the duct you have to 2500 mm. You want a duct that is 2000 mm. Set the scale to 493 mm (2500 - 2000 - 7 = 493).

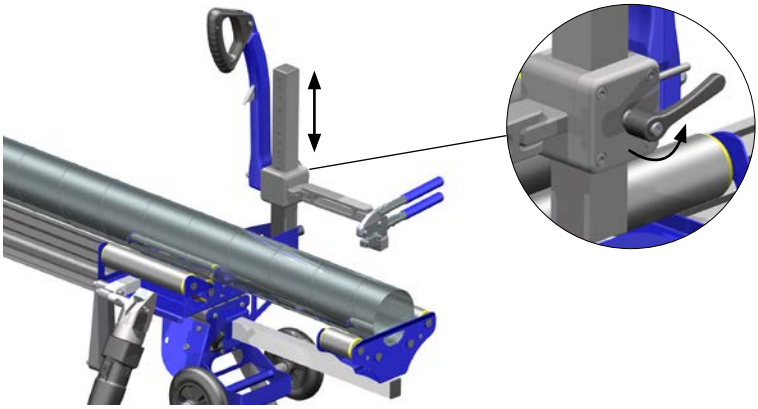
Position the duct





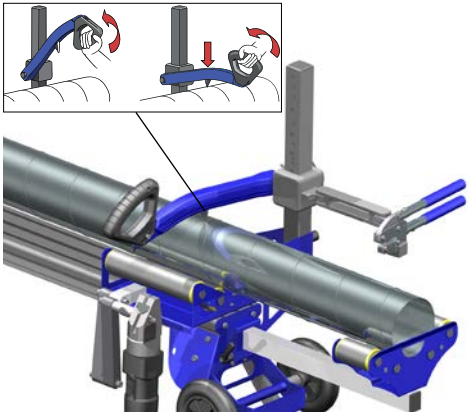
1. Turn the duct so that the opening of the fold is facing you.
2. Place the duct on the bench.
3. Push the end of the duct towards the stopper on the telescopic arm.
4. Adjust the slidable duct support so it is as close as possible to the duct end.

Adjust the knife arm so that it matches the duct's diameter



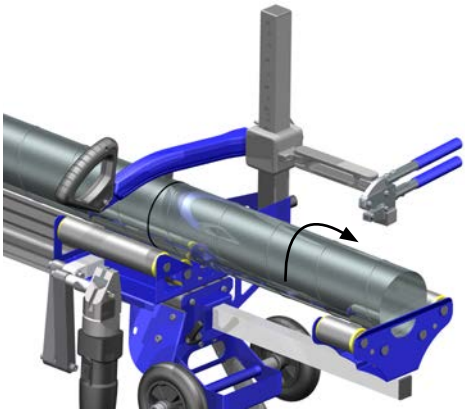
1. Loosen the locking handle on the setting block.
2. Move the block so that top of the block is at the mark of the duct's diameter.
3. Tighten the locking handle.

Make a hole with the knife



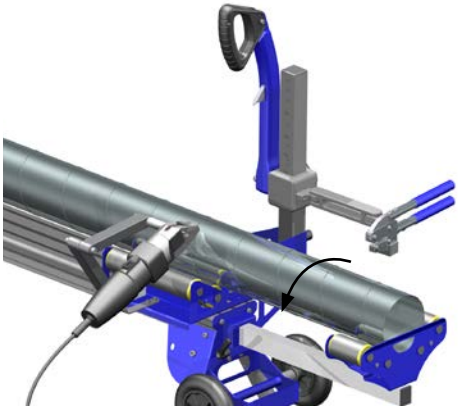
1. While moving the arm downwards turn the handle so that the knife protection is retracted
2. Rotate the duct so the knife hits the duct a bit "before" the duct's spiral fold.
3. Hold the duct with one hand.
4. Press the knife arm firmly downwards until the knife arm touches the duct.

Scratch a line with the knife



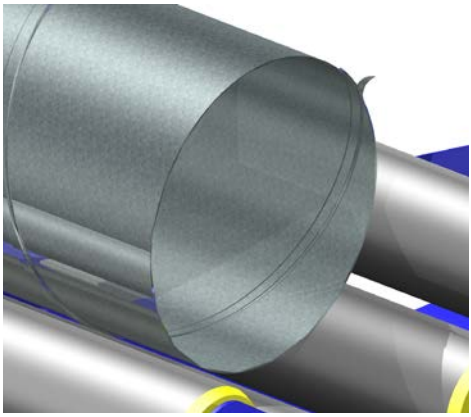
1. Scratch a thin line with the point of the knife around the duct. The easiest way to do this is turning the duct away from you.
2. Use the scratched line as a guide to cut straight.

Cutting the duct with the shears



1. Start the shears.
2. Insert the shears' cutting tooth into the hole.
3. Turn the duct almost one full turn towards you. Make sure the scratched line is in the centre of the strip that is cut off.
4. Do not turn the last bit but hold the duct still and lead the shears forward instead.

Cutting the needle



When cutting the needle Lindab recommends that you use the needle plier, NCP

Lindab recommends to cut **the outer needle** from Ø 100 and upwards and to cut **the inner needle** from Ø 315 and upwards.

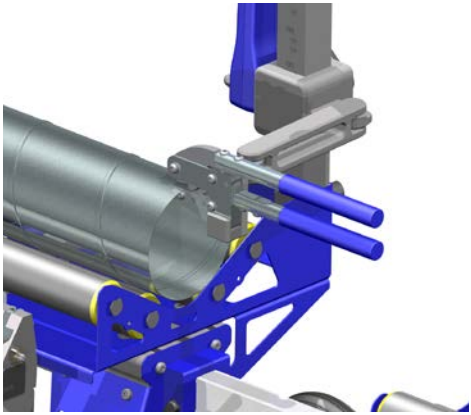
Making notches

The correct click pliers

Use the correct click plier to get the notches at right distance from the ducts end.

Use the 40-pliers for Ø 80–224 (Ø 3"-9").
Use the 60-pliers for Ø 250–315 (Ø 10"-12").

Making notches



For the recommended number of notches, see "Assembly Instructions Lindab Safe and Lindab Safe Click".

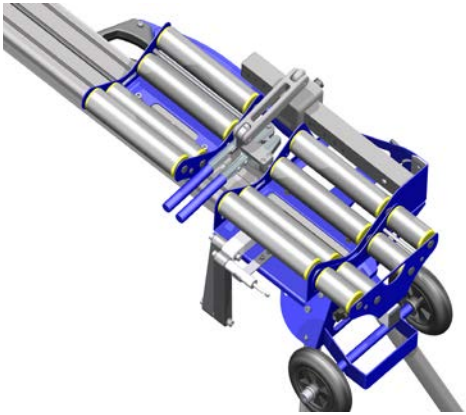
1. Insert the opening of the pliers over the duct end as far as it can reach.
2. Keep in place by holding the duct with your other hand.
3. Press the handles fully together.
4. To control the notch, see the instructions for "Checking the notch".
5. Place the notches evenly around the circumference.

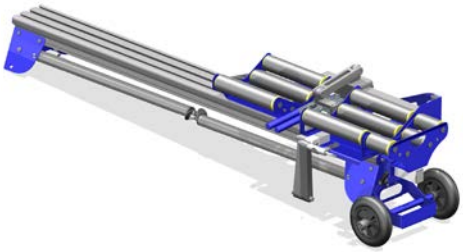
You can easily loosen the pliers from the arm for separate use.

Moving the bench

1. Push in the telescopic arm and lock the handle.
2. Move the slidable duct support as close to the fixed as possible.
3. Lower the knife arm.
4. Hold onto the handle and turn in the legs on the wheel side.
5. Move the bench as shown in the picture.

Fold the bench as small as it will go e.g. for stowing in a car





1. Move the setting block so that the top of the block is above the 250 mark.
2. Move the knife arm to its vertical position.
3. Move the the stand to its horizontal position.
4. Move the click plier so that it is positioned horizontally above the bench between the slidable and the fixed duct support.
5. Remove the shears.
6. Turn the legs in.

Problem solving

Problem	Cause	Solution
The knife is difficult to press through the duct.	The knife is blunt.	Remove and sharpen the knife or replace it with a new one.
	The knife arm is set at an incorrect height.	Move the setting block so that the mark above the block is the same as the diameter of the duct.
The cutting tooth of the shears cannot enter the knife hole.	The tooth does not hit the hole.	Check that the edge of the knife touches the centre of the shears' tooth.
	The hole is too small. The knife arm was not pressed all the way down to the duct when the hole was made.	Press the arm all the way down to the duct.
	The hole is too small. The knife arm is set at an incorrect height.	Move the setting block so that the mark above the block is the same as the diameter of the duct.
The duct is difficult to cut with the shears.	The shears are blunt.	Remove the cutting tooth of the shears and replace it with a new one. (After very heavy wear the side cutter may also need to be replaced.) See the chapter on spare parts.
	The opening of the fold is turned away from the shears.	Turn the duct so that the opening of the fold is facing the shears.
The fold is difficult to cut with the shears.	The knife hole was made in the wrong place.	Make the knife hole in the place, i.e. just before the fold.
	The shears are blunt.	Remove the cutting tooth of the shears and replace it with a new one. (After very heavy wear the side cutter may also need to be replaced.) See the chapter on spare parts.
	The wrong work method is being used.	Press the shears forward a bit harder but make sure you work them upwards and downwards.
The duct was not cut off properly and has a nick.	The bearing pivots points for the shears or knife are too loose.	Check that the edge of the knife touches the centre of the shears' tooth.
	The shears were forced to the left or right during cutting.	Before cutting, scratch a thin line with the point of the knife around the duct. Make sure the scratched line is in the centre of the strip that is cut off.

Problem	Cause	Solution
The cut duct is the wrong length.	The scale is set to an incorrect length.	Set correct length on the scale.
	During cutting, the duct was not pressed close enough to the stopper at the end of the telescopic arm.	Press the duct close to the stopper.
	The fixed duct support has come loose from the bench.	Fix the support with its two tightening screws. Make sure that the free distance between the closest edge of the shears' cutting tooth corresponds with the marking on the scale.
The click pliers make holes in the duct.	The pliers' stop screw has been screwed in too far.	Unscrew the stop screw slightly. Check how the notch looks, see instructions for "Checking the notch".
The click pliers make a faint notch.	The pliers' stop screw has been unscrewed too far.	Screw the stop screw in slightly. Check how the notch looks, see instructions for "Checking the notch".
The click plier makes dents in the duct next to the notch.	The pliers' stop screw needs adjusting due to the sheet metals thickness or quality.	Adjust the stop screw. Check how the notch looks, see instructions for "Checking the notch".

Bench (SR Cutter)

Bench

SRCS2 3000 103 427

SRCS2 3000 US 103 428

Spare parts

Roller (100) + bushings

CSPR2 100 103 493

Roller (250) + bushings

CSPR2 250 103 494

Bushings, 2 pcs

CSPRB2 103 495

Arm for click plier

CSCPS2 103 430

Pin for Dräco

CSSAA2 103 498

Knife blade

CSKE2 103 496

Foot for leg

SRCSF2 103 497

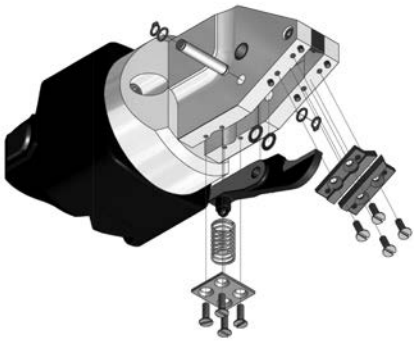
Knife protection

CSKP2 112 787

Knife arm + tension block

SRCKA2 115 699

Shears (Dräco 3514-7R)



Shears 3514-7R	
CSS EU 230	226 607
CSS UK 110	226 609
CSS CH 230	226 608
CSS US 110	100 886

Spare parts

Shears cutting tooth 37140

CSSK 226 611

Pin set for shears cutting tooth 37140

CSSKPS 100 146

Shim set for shears cutting tooth 37140

CSSSSS 100 147

Side cutting edges for shears

SJS 226 623

Screw and pin set

SSPS 100 148

Click pliers

Click pliers

CSCP 40	100 754
CSCP 60	100 755

Spare parts

Gauge

CSNC	100 096

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1077 EN 2013-05-31